

Date: Wednesday, 2/8/2006 7:06:50 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 25732	
Estimate Number : 11464	
P.O. Number : N/A	Part Number : D314089
This Issue : 2/8/2006	Drawing Number : D3140 REV D
S.O. No. : N/A	Project Number : N/A
Prsht Rev. : NC	Drawing Revision : D
First Issue : N/A	Material : N/A
Previous Run : N/A	Due Date : 2/15/2006
Written By : SEE COMMENT BELOW	Qty: 4 Um: Each
Checked & Approved By : <u>LA</u>	
Comment : Est. A02.04.30 New Issue NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 1.8812 sf(s)/Unit Total : 7.5247 sf(s)

2024-T3 .032 sheet

Matl: 2024-T3 (QQ-A-250/4) .032" thick

(M2024T3S.032)

Batch M18147

ml 06/02/09

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blanks.

Blank size: 6.00" x 43.00" x .032" thick

ml 06/02/09

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA226

Deburr break all unmarked sharp edges .005 to 0.010

Stack of 15

make by hand
1:1 dig.

ml 06/02/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06-02-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/20

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06-02-17 (4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA 06 02 17

4

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C206102117 (4)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Sue 06/02/20 (4) 06/02/20

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries